



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2850-1

Job Sheet 184888



Part No: D2850-1

Job Qty: 10 ea

Part Name: End Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP B 98.12.07 Changed folio DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-1		Marie L 11/1/18
100	Bandsaw	10 pcs	11/2/18	11/2/18	0.00	0.08	Bandsaw1		11
110	CNC Vertical Machining	10 pcs	11/2/18	11/2/18	0.20	6.99	HAAS1-2		11
130	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-1		
140	Packaging	10 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1		
150	QC21-SA	10 Ea	11/2/18	11/2/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: 3.8"

Descriptions: 110 - Machine per Folio D2850-1 Deburr and Tumble

140 - *** STOCK IN STEP CELL ***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.500	6061-T6 Bar 2.50 X 1.50	3 ft (.3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.500X01.500	3	15	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	High Float Step End Bracket	1.720inches + 0.000 - 0.030	1.720 1.690		
2	High Float Step End Bracket	0.178inches ± 0.010	0.188 0.168		
3	High Float Step End Bracket	0.100inches ± 0.030	0.130 0.070		
4	High Float Step End Bracket	30.000Degrees ± 0.500	30.500 29.500		
5	High Float Step End Bracket	2.150inches ± 0.030	2.180 2.120		
6	High Float Step End Bracket	0.375inches + 0.010 - 0.100	0.385 0.275		

10.10

7	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115
8	High Float Step End Bracket	1.000inches $\pm$ 0.030	1.030 0.970
9	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115
10	High Float Step End Bracket	19.200Degrees $\pm$ 0.500	19.700 18.700
11	High Float Step End Bracket	0.125inches $\pm$ 0.010	0.135 0.115
12	High Float Step End Bracket	0.750inches $\pm$ 0.010	0.760 0.740
13	High Float Step End Bracket	0.600inches $\pm$ 0.010	0.610 0.590

Plex 10/17/18 1:28 PM Dart.lajeunesse.marie



Container No: S124210



Part: D2850-1

Job No: 184888

Serial No/Batch: S124210

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/02/18

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier ☐</td> </tr> <tr> <td></td> <td></td> <td></td> <td>Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐				Quality ☐																														
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Date : 18/11/22		Sequence #: 170		QTY Affected : 10		MRB (QSI042) 1 MSP 12 4/18/11/22																																													
Description Work Order Deviation Ro.25 Fillet is Ro.13				Disposition SCRAP. STRESS INCREASE ≈ 20%, may lead to cracking.		Completed By [Signature] 18/11/22 Lead hand / Supervisor DAS 9 9-89 15-11-22 QC / QA Coordinator DAS 9 9-89 15-11-22																																													
Root Cause <table style="width:100%;"> <tr><td>Operator</td><td>☒</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Preservation</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Human Factors</td><td>☐</td></tr> </table>		Operator	☒	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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